

# Work Order ID 70628

Friday, June 10, 2011 2:27:06 PM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 6/10/2011 Start Qty: 14.00

Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 14.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3571	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.90 " long

OK 11/06/21

15

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A 2-Deburr  
per dwg D3571

B.A 11/06/23

15

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/06/23

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 70628

Friday, June 10, 2011 2:27:06 PM



Page 2

Item ID:	D3571-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Guide					
Start Date:	6/10/2011	Start Qty:	14.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	14.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>11/06/24</i>		<i>15</i>	<i>0</i>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							<i>15X 0 m-f 11/06/24</i>
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo	0.00  0.00							<i>15X 0 m-f 11/06/24</i>

*M 115128*

START TIME: *9:00*  
FINISH TIME: *9:30*  
OVEN TEMPERATURE: *320°F*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 70628**

Friday, June 10, 2011 2:27:06 PM



Page 3

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 6/10/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

15  $\phi$  BR 11-6-24

170

Identify as per dwg &amp; Stock Location: 248

0.00



Packaging

Memo

0.00

Packaging

Rec'd 11/6/24 (15)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

27 11/6/27

ME  
11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 10, 2011 2:27:11 PM

Page 1

Work Order ID: 70628



Parent Item: D3571-1

Parent Item Name: Guide

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	21.1912	0.241	3.551579			



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT003

21.1912

116405

0.4492

116604

1.5

116623

19.242

3.80 on 6/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70628
<b>Description:</b> Guide		<b>Part Number:</b>	D3571-1
<b>Inspection Dwg:</b> D3571 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.698	✓		Vern	GA-01
Ø1.00 Depth 100	+/-0.010	Ø1.000 x .100	✓		"	"
2.75	+/-0.030	2.750	✓		"	"
1.38	+/-0.030	1.374	✓		"	"
1.25	+/-0.030	1.250	✓		"	"
0.63	+/-0.010	0.625	✓		"	"
0.031 chamfer	+/-0.010	0.033 chamfer	✓		"	"
Ø0.500	+0.006/-0.001	Ø0.503	✓		"	"
Ø0.201	+0.005/-0.001	Ø0.203	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.260	+0.000/-0.010	0.256	✓		Vern	GA-01
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø0.384 x 100°			"	"
0.125	+/-0.010	0.128	✓		"	"
2.250	+/-0.010	2.244	✓		"	"
0.250	+/-0.010	0.253	✓		"	"
0.188	+/-0.010	0.189	✓		"	"
0.063 chamfer	+/-0.010	0.064	✓		"	"

<b>Measured by:</b> H.A.	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/06/23	<b>Date:</b> 11/06/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

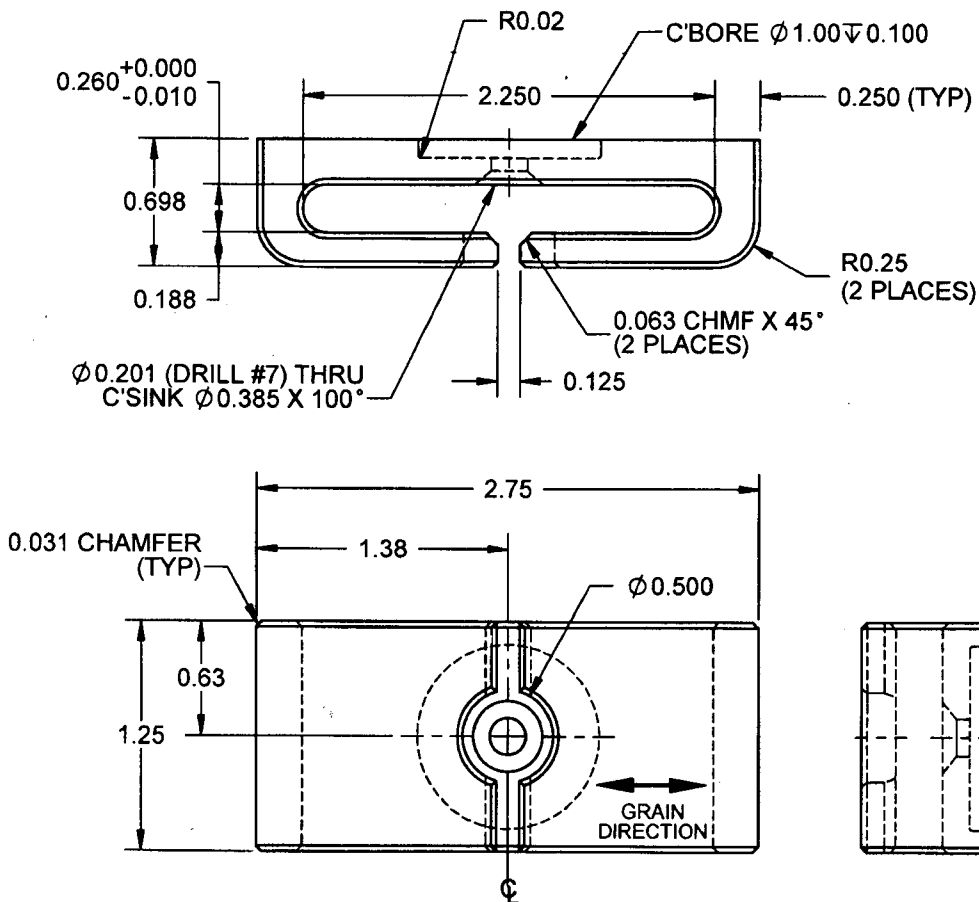
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**NOTE:** Date & initial all entries

**DART**

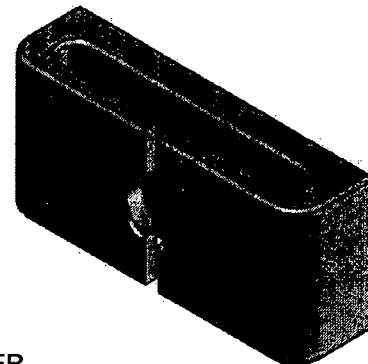
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3571</b>	REV. A SHEET 1 OF 2
DATE <b>07.01.29</b>	TITLE <b>GUIDE</b> SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

**RELEASED**07.01.12 *[Signature]*

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *70628*

*PL 11-06-10***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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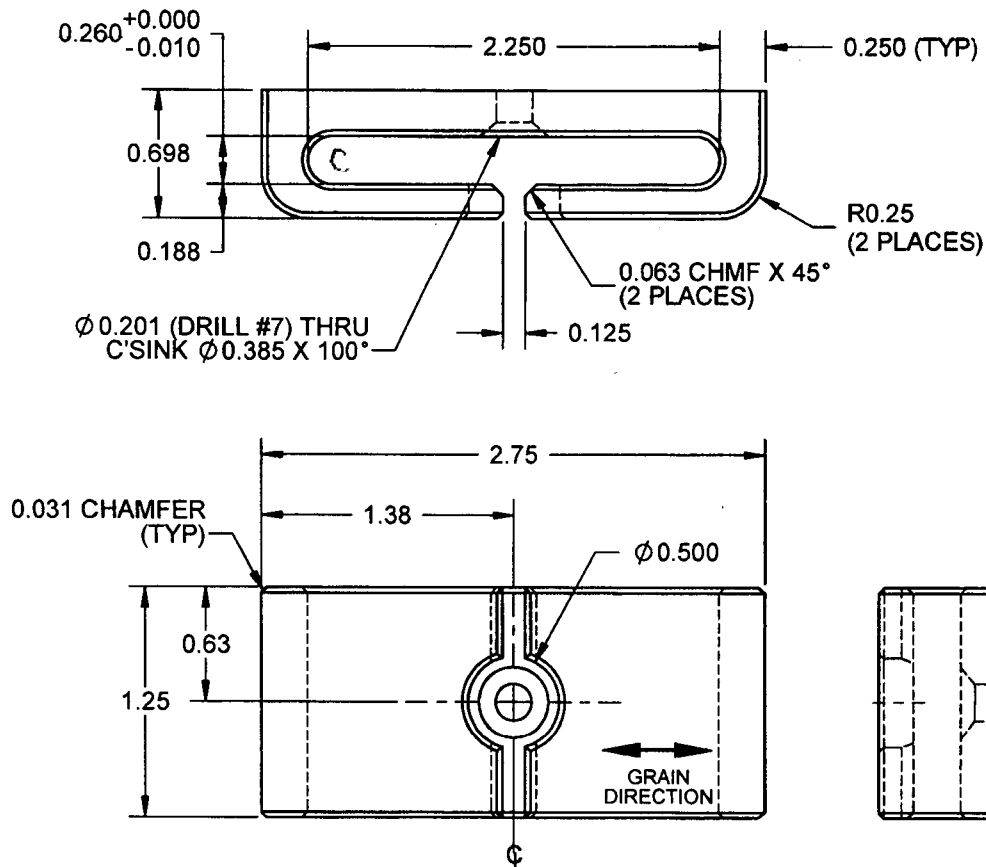
**NOTE:** Date & initial all entries



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DATE 07.01.29		TITLE GUIDE	SCALE 1:1

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07.01.12 *[Signature]*

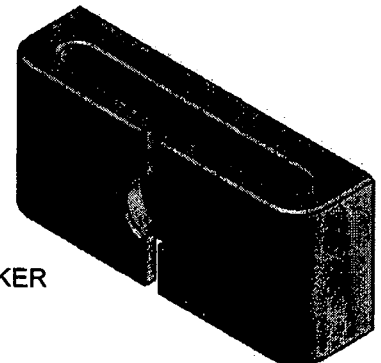
*w/o 70628*



### D3571-3 GUIDE

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ⊥



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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries